

SHIP TO EAGLE 10/07!

Work Order ID 48625

Friday, June 26, 2009 12:33:58 PM

Page 1

Item ID: D3924-1

Accept

Revision ID:

A DEL 7/09 07 09

Item Name:

SHIM

Start Date:

7/15/2009

Start Qty: 20.00

Required Date: 8/3/2009

Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3924

A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg
Dwg Rev: A-Relin
Prog Rev: A-Relin

2-Deburr if necessary

0.00

⇒ ml 09 07 09 (20)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

⇒ ml 09 07 09 (20)

PRELIMINARY ISSUE

Delrin 125

B# 104803

ml 09 07 09

Work Order ID 48625

Friday, June 26, 2009 12:33:58 PM



Page 2

Item ID: D3924-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: SHIM

Start Date: 7/15/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



0.00

QC

Memo

Quality Control

=>

S 07/07/10

(20)

ENGINEERING
APPROVAL

130

0.00



0.00

Small Fab

Memo

Small Fab

C'SINK AS PER DWG

SAD 07-07-10

Qty

(20)

140

QC5- Inspect part completeness to step on W/O

0.00



0.00

QC

Memo

Quality Control

S 07/07/10 (20)

MP 07/07/10

ENGINEERING
APPROVAL

Work Order ID 48625

Friday, June 26, 2009 12:33:58 PM



Item ID: D3924-1	Accept		Setup	Start	
Revision ID: A				Stop	
Item Name: SHIM					
Start Date: 7/15/2009	Start Qty: 20.00		Cust Item ID:		
Required Date: 8/3/2009	Req'd Qty: 20.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Identify as per dwg & Stock Location: <u>139</u>	0.00							
Packaging	Memo	0.00	Don took 4 for show HTS trade			9/7/10		90x54	
Packaging						P8/4/4 (14)			
160 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00				09/09/08		mf 09-09-08	
Quality Control									

POSITIVE RECALL
EFFECTIVE 9/8/07 AUTH AL
RELEASED W DATE 9/10/07

Date: Wednesday, 17/06/2009 10:31:00 AM
User: Melanie Fauteux











Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHIM	<i>Done - No Route</i>
Job Number : 48625		
Estimate Number : 14022		
P.O. Number :	Part Number : D39241	
This Issue : 17/06/2009 S.O. No. :	Drawing Number : D3924 REV A	
Prsht Rev. : NC	Project Number : N/A	
First Issue : // Type : SMALL /MED FAB	Drawing Revision : A	
Previous Run :	Material :	
Written By :	Due Date : 24/06/2009 Qty: 20 Um: Each	
Checked & Approved By : <u>MF 09-06-17</u>		
Comment : Est Rev:A 09-06-09 new issue EC verified by:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0 ✓	WATER JET	FLOW WATER JET
		
	Comment: FLOW WATER JET 1-Cut as per Dwg Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary	
2.0	MLEXS125 9034 01	1/8" 9034 Lexan Sheet
		
	Comment: Qty.: 0.0053 sf(s)/Unit Total : 0.1050 sf(s) 1/8" 9034 Lexan Sheet	
3.0 ✓	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0 ✓	QC8	SECOND CHECK
		
	Comment: SECOND CHECK	
5.0 ✓	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
	Comment: SMALL & MEDIUM FAB RESOURCE 1 C'sink as per dwg	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 17/06/2009 10:31:00 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHIM

Job Number: 48625

Part Number: D39241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify as per dwg and Stock

Location: _____

8.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

C

B

A

R0.06
TYP

Ø0.148

45 DEC
C-SINKJMP
09/07/10

Ø0.190

0.63

0.31

0.156

0.500

0.844

1.00

0.125

D3924-1 SHIM

NOTES:

- 1) MATERIAL: 9034 BLACK LEXAN SHEET (SMOOTH) 0.125 THICK
REF DART SPEC M-LEXS.125-9034-02
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3924-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01 lbs

8

7

6

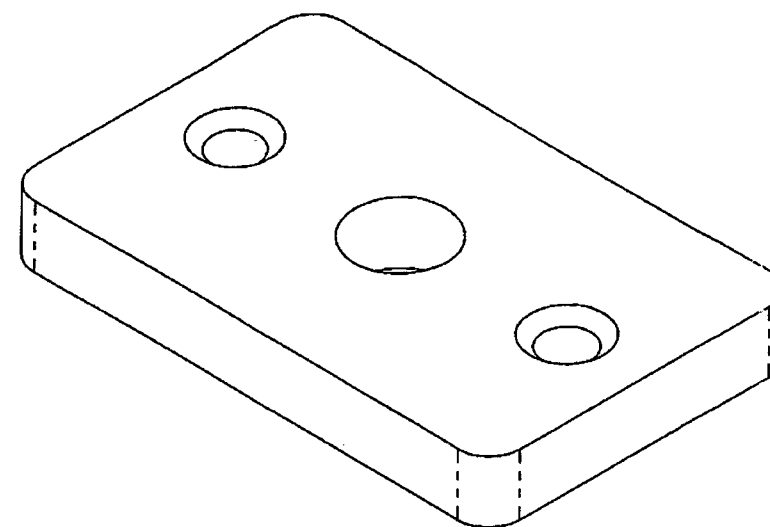
5

4

3

2

1



PRELIMINARY ISSUE

JMP 09/06/08

Dane E

A	NEW ISSUE	BY	09.03.30
REV.	DESCRIPTION		DATE
DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	FE	D3924	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SHIM	NTS
DATE	09.03.30	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT IT	

Date: Thursday, 25/06/2009 11:30:26 AM

User: Melanie Fauteux

Bill of Manufacturing

Part Number : D39241

Revision : A

Drawing Name : SHIM

Default Qty. : 1

Seq #	Item	Description	Qty	U/M	Unit Cost	BOM Cost
1	WATER JET	FLOW WATER JET	0.00	Hours	112.00	0.00
2	MLEXS125 9034 01	1/8" 9034 Lexan Sheet	0.00	sf	2.86	0.01
3	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	0.00	Hours	45.00	0.00
4	QC8	SECOND CHECK	0.00	Hours	43.00	0.00
5	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	0.00	Hours	57.00	0.00
6	QC5	INSPECT WORK TO CURRENT STEP	0.00	Hours	0.00	0.00
7	PACKAGING 1	PACKAGING RESOURCE #1	0.00	Hours	56.00	0.00
8	QC21	FINAL INSPECTION/W/O RELEASE	0.00	Hours	0.00	0.00
Total BOM Cost						0.01

Jean-Luc Menard

From: Harvey Siemens [hsiemens@dartaero.com]
Sent: July 6, 2009 9:14 AM
To: 'Jean-Luc Menard'
Cc: 'Mike Petsche'
Subject: RE: D3924-1 SHIM

Sorry for taking so long Jean-Luc. I guess I didn't let you know that I would be away and that Kevin could answer the JAR OPS 3 questions. So hopefully you have this info already but yes the holes are 0.098 (#40)

Regards,

Harvey Siemens

Mechanical Designer
 DART Aerospace Ltd.

P: 403-717-0328
 F: 403-717-1288
 E: hsiemens@dartaero.com
 W: www.dartaero.com

M: 1060 McTavish Road NE, Calgary, Alberta, T2E 5G9

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From: Jean-Luc Menard [mailto:jmenard@dartaero.com]
Sent: Wednesday, July 01, 2009 5:46 AM
To: Harvey Siemens
Cc: Mike Petsche
Subject: D3924-1 SHIM

Hi Harvey,
 What is the dia on the 2x small holes with the .146" c'sinks?
 I'm thinking .098"?
 Let me as soon as you get this so we can cut the parts.
 Thx
 JLM

Jean-Luc Menard

Production Engineering Coordinator



1270 Aberdeen Street
 Hawkesbury Ontario
 Canada K6A 1K7
 Tel: (613) 632-5200 Ext 227

jmenard@dartaero.com

06/07/2009

Receiving Report

Date: 7/4/21
 Supplier: BK

Batch No: M104803
 Dart P/O: 3947

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☒ No ☐ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection 07-06-25 N/A ☒
 Work Order N/A ☐

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin: 07/06/26
 Date: 07/06/26
 Received/Costing: R/P 4947
 Initial: CR

Location

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

**** PLEASE NOTE: IF YOU WOULD LIKE TO HAVE FUTURE INVOICES FAXED OR E-MAILED TO YOU PLEASE MAIL OR FAX A COPY OF THIS INVOICE TO OUR BRAMPTON LOCATION WITH YOUR INFORMATION****
 THANK YOU
 EMAIL/FAX INFO

PLEASE Remit To: GE Polymersshapes 9150 Airport Road Brampton ON L6S 6G1 Tel: 905-789-3111 Fax: 905-789-3152
 NO GOODS TO BE RETURNED WITHOUT APPROVAL FROM US. ALL DISCREPANCIES MUST BE REPORTED WITHIN 3 DAYS.

DART

Purchase Order

Date	Page
Jun 11, 2007	1
Purchase Order Number	
PO00003947	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FAKED
Verneil

Vendor Address:

G E Polymershapes
9150 Airport Road
Brampton, ON L6S 6G1
Canada
Phone (416) 745-7043
Fax (613) 745-4291

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-GEP001	Jun 11, 2007	N30	Purolator	Jun 15, 2007

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
16.0000	MDELRINS0125	Black Delrin Sheet .125 Comments: MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL NOTE: SHEET 2 X 4 FT	6/15/2007	No	9.375000	sf	150.00
<div>CERTIFICATE OF CONFORMITY REQ'D UPON DELIVERY</div>							
Comments:		Tax Summary:		Less:			
		GST		included tax		0.00	
		GSTME		Subtotal		150.00	
		GSTND		Total tax		9.00	
Entered By: CL		CLAVOIE		Total purchase order in			
Approved By: W				CAD Dollars		159.00	



GE
Plastics
Polymershapes

GE Polymershapes

1250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3
TEL: 613 745 7043 FAX: 613 745 4291

CERTIFICATE OF COMPLIANCE

SOLD TO DART AEROSPACE

DATE: 6/22/2007

YOUR PURCHASE ORDER : P00003947

OUR SHIPPER NO. 077743

INVOICE NO: 0077836

LINE ITEM #: 001

QUANTITY: 2 SHEETS

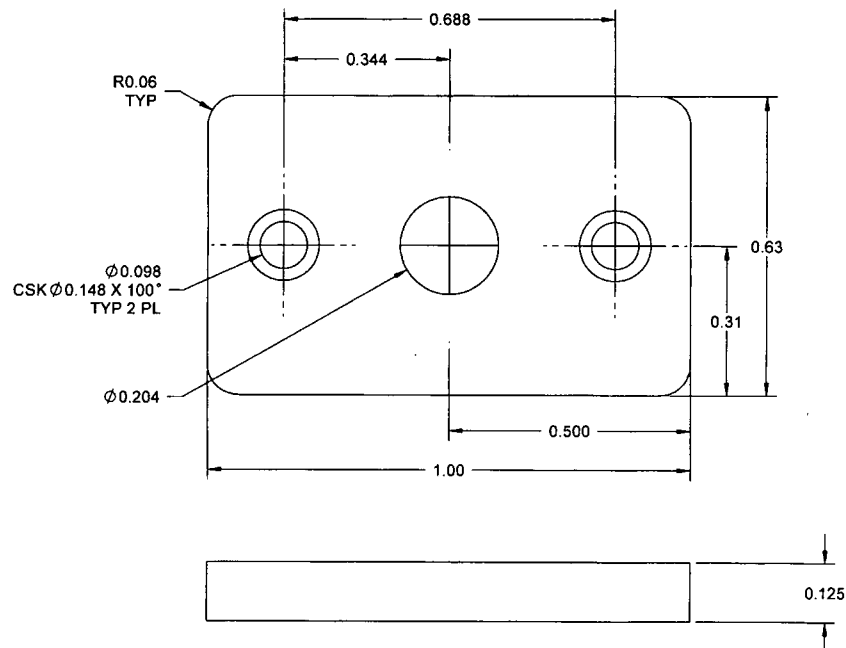
DESCRIPTION: 125 X 24 X 48 ACETRON GP PLATE- BLACK

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: ASTM-D-6100

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

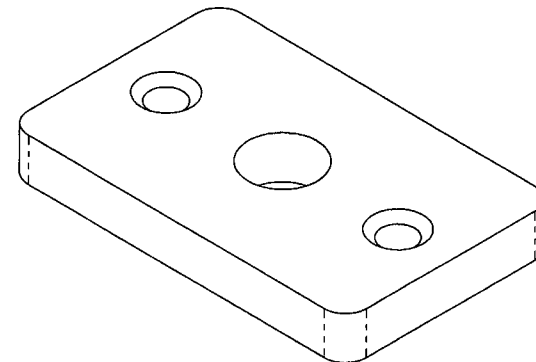
AUTHORIZED REPRESENTATIVE SIGNATURE

Darleen Melkert
Inside Sales



D3924-1 SHIM

- NOTES:**
- 1) MATERIAL: 9034 BLACK LEXAN SHEET (SMOOTH) 0.125 THICK
(REF DART SPEC M-LEXS. 125-9034-02)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.01 lbs



RELEASED
2009-08-28
MP

A	NEW ISSUE		09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	ALS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.03.30		
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries